

Work Order ID 97385

97385

February 19, 2013 9:53:43 AM

Page 1

Item ID: D2153

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Door Prop

Stop

NS2

Start Date: 2/19/13

Start Qty: 36.00

36

Cust Item ID:

Required Date: 2/25/13

Req'd Qty: 36.00

36

Customer:

Reference:

Approvals: Process Plan: CL

Date: 13/02/19 Tooling:

Date:

Run

Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sec. 100
Work Center

Operation
Description

Set up/
Run Hours

Part ID

Tool #

Plan

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D2153	Rev A1

100

100

PURCHASING

Memo

0.00

CL 13/02/19 (36)

Purchasing

Issue P/O: 19119 Gas Spring P/N: SL13-10 (10lb) Possible
supplier: Spring Lift Corporation**Note: Do not ship by air****Allow an
extra 7 to 10 business days for shipping**Material release note is required

110

110

Receive & Inspect for Damage & Mat'l Certs

0.00

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

13/02/13 (36)

120

120

QC6- Inspect dimensions to drawing

0.00

QC

Memo

0.00

Quality Control

Inspect Test Spring is 10lb

DAS
21
36-B

36

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
				Bending <input type="checkbox"/>	Grain <input type="checkbox"/>	Ovalized <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>				
				Centre Not Concentric to O/S <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>				
				Cracks <input type="checkbox"/>	Broken/Damaged <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Weld <input type="checkbox"/>				
				Crushed/Crimped. <input type="checkbox"/>	Burrs <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>				
				Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Part Moved <input type="checkbox"/>					
				Heat Treat <input type="checkbox"/>	Countersink <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>					
				Inspection Strip in Tube <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Other <input type="checkbox"/>				
				Ripples in Bend <input type="checkbox"/>	Drill Holes <input type="checkbox"/>						
				Torque Waves in Extrusion <input type="checkbox"/>	Drawing <input type="checkbox"/>						
				Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>						
				Wave/Twist in Tube <input type="checkbox"/>	Folio <input type="checkbox"/>						

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Page 2

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36

Cust Item ID:

Required Date: 2/25/13 Req'd Qty: 36.00

36

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

130

130

Small Fab

Small Fab

Small Fab

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

36x

1X

13/03/14

10
next page

Small Fab

Memo

0.00

1- Assemble as per Dwg D21532- Remove Spring Lift name and address with
Acetone, leave only warning: "DO NOT OPEN HIGH PRESSURE"

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

DAS
21
13 3 18

36
1X
13/03/14

150

150

Packaging

Packaging

Identify as per dwg & Stock Location:

5060

0.00

Memo

0.00

13/03/14 36

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA dh Date: 13/04/01

QA Closed: ✓ Date: 13/3/20

Work Order: <u>97385</u>	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
Part No. <u>D 2153</u>	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
NCR No. <u>13-1489</u>	Scrap <input checked="" type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>		
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>		
	Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input checked="" type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier	X								
Training									
Unapproved									
	13/03/14	130	1	Found 1 part with no written on it By supplier.	DAS 16 Q3/14/2 13/3/20	Scrap & destroy No replace	SB 13/03/14	DAS 27 Q3/14/20 13/3/20	B3 1D Q3/14/20 13/03/20

FAULT CATEGORY

Landing Gear	General			
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain	<input type="checkbox"/> Ovalized	<input type="checkbox"/> Pressure/Forced
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Temperature/Cure
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Weld
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Wrong Stock Pulled
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance	<input type="checkbox"/> Part Moved	
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Positioned Wrong	
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread	<input type="checkbox"/> Power Loss/Surge	
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset		
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration		
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence		
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions		
			<input type="checkbox"/> Other	

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Page 3

February 19, 2013 9:53:43 AM

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Accept

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Start

NS1

Revision ID:

Stop

NS2

Item Name: Door Prop

Start Date: 2/19/13 Start Qty: 36.00

36

Cust Item ID:

Required Date: 2/25/13 Req'd Qty: 36.00

36

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

M-L-J 13-03-20

160

QC

Quality Control

Memo

0.00

BLB-03-19

Picklist Print

February 19, 2013 9:53:42 AM

Page 1

Work Order ID: 97385

Parent Item: D2153

Parent Item Name: Door Prop

Start Date: 2/19/13

Required Date: 2/25/13

Start Qty: 36.00

Required Qty: 36.00

Comments: IPP: E 02.07.08 Re-format KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD516 Washer	NAS1149D0563J	Purchased	No	4D M122452 (702)		130	Each	2.0000	2	72	6	JP, 13/03/14	
D2153P Door Prop		Purchased	No		ST504		Loc Qty	2					
D3015-3 Locknut		Manufactured	No		1069059		Loc Qty	2					
SL69-BS Ball Stud		Purchased	No		ST023		Loc Qty	195					
					92381		Loc Qty	45					
					95758		Loc Qty	100					
					96151		Loc Qty	50					
					100		Loc Qty	266.0000					
					GA		Loc Qty	212					
					123498		Loc Qty	12					
					124455		Loc Qty	200					
					ST397		Loc Qty	54					
					118145		Loc Qty	54					

NCR: Yes / No

DQA: _____ Date: _____

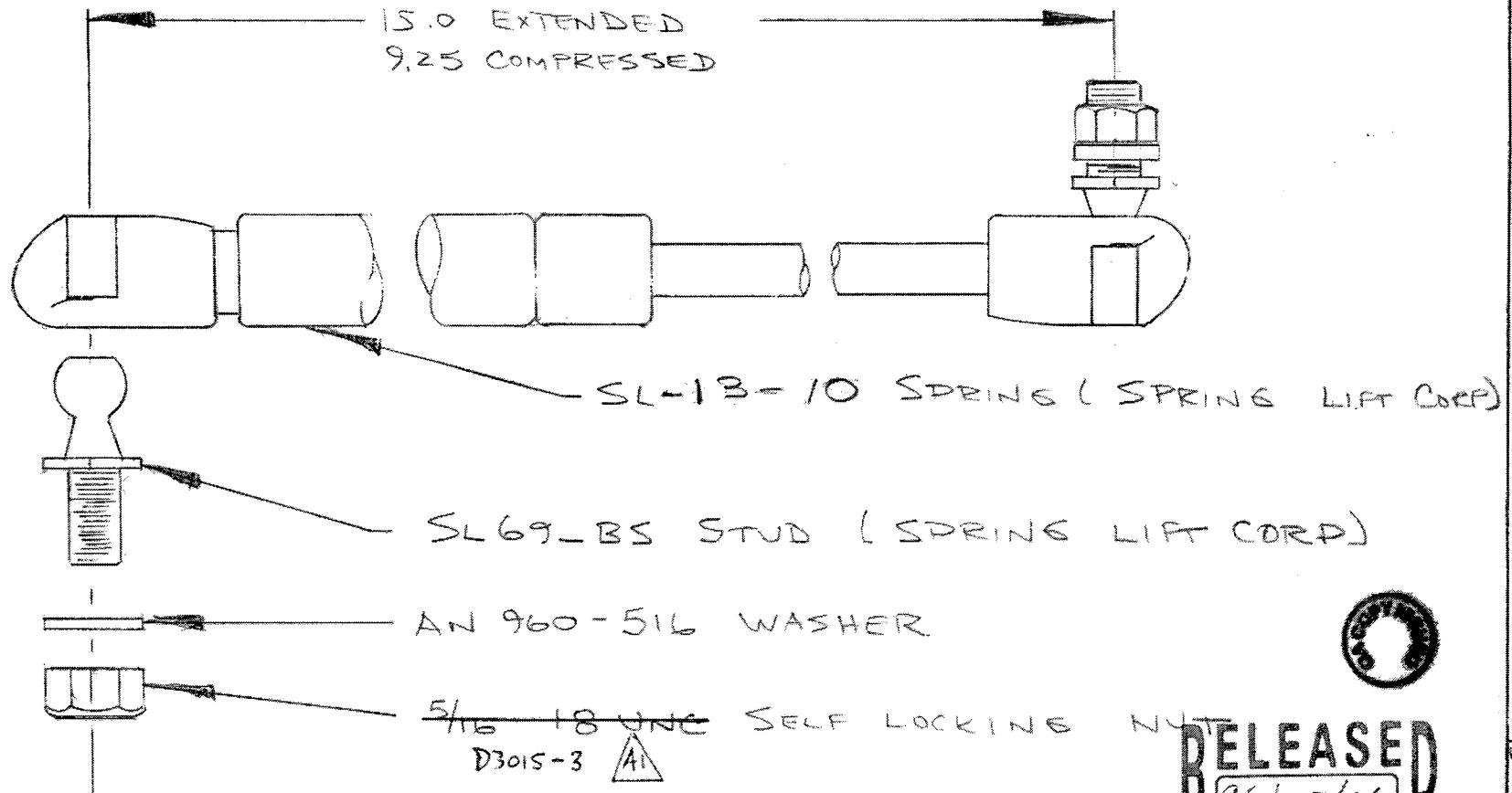
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS									
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other								
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector				
Doc/Data															
Equip/Tooling															
Operator															
Material															
Setup															
Other															
Process															
Supplier															
Training															
Unapproved															
FAULT CATEGORY															
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions								<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other			

CL 13/02/19

W10. 97385



RELEASED
96/07/16

A1	A	REVISION			RIVET CODE SHALL BE PER NAS 523	PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR	
<i>JK</i>	<i>JK</i>	DRAWN	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		BASIC CODE D=DIMPLE D=NO. OF SHEETS C=COUNTERSINK	DASH NO. F=HEAD NEAR SIDE F=HEAD FAR SIDE	DRAWN HATTON	DATE 07.2.8.72	DART AERO ACCESSORIES INC. VANCOUVER CANADA		
<i>il</i>	<i>il</i>	APPROVED									
DESCRIPTION OF CHANGE		REQUIREMENTS - UNLESS OTHERWISE SPECIFIED		TOLERANCES - .000 & .000 .000 & .010 .000 & .000 .000 & .000 .000 & .000		BASIC CODES B=MS20470AD B=MS20470AD	DRAWN HATTON	DATE 07.2.8.72	GAS SPRING ASSEMBLY		
		GENERAL		LIMITS							
01/05/99 CHANGE TO DRAFT-3 SL 13-10 W10. 97385		1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS .015 MAX 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER IN. - 5. 1742 5. HOLES PER INCH 10367		1. TOLERANCES - .000 & .000 .000 & .010 .000 & .000 .000 & .000 .000 & .000							
REPORT ALL DISCREPANCIES - DO NOT SCALE											



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO19119**

Purchase Order Date 2/19/13
PO Print Date 2/19/13

Page Number 1 of 1

Order From :

ATTWOOD
25349 NETWORK PLACE
CHICAGO, IL 60673-1253
US

VU-ATT001

Contact Name	Buyer	Chantal Lavoie
Vendor Phone	Requisition Nbr	
Vendor Fax	Tax Resale Nbr	10127-2607
Vendor Account Nbr	Terms	Net 30
	Currency	USD
	FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED
2/19/13

Line Nbr	Reference Revision ID	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2153P	Door Prop	2/25/13 Yes	36.00 Each	FedEx PI collect	\$4.1300	\$148.68

Special Inst: AS PER DWG D2153 REV. A
B97385
GAS SPRING P/N: SL13-10 (10 LBS)

PO Total: \$148.68

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

u *CL*
No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required - YES NO

Change Nbr: 1

Change Date: 2/19/13



TELEPHONE: 616-897-2290

MotorGuide®
NEVER STOP.

CUST #: 68580 MST #: 11395-00

COLLECT 151793840

PRO NO: 778104464
SHIP VIA: FEDEX GROUND
BOL #: 00226970003402339

BILL TO: DART AERO LTD.
REQ: 02/22/13

FREIGHT:

F ATTWOOD / MOTORGUIDE,
R
O 1016 NORTH MONROE
M LOWELL, MI 49331-0260

INCOTERMS: EXW SHIPPER DOCK

T DART AERO LTD.
O 1270 ABERDEEN STREET

HAWKESBURY ON K6A 1K7

CRTS #: 1 PO#: P019119

WGT #: 12 DATE #: 03/03/13

SPUR:

LABEL NO:

--ROUTING GUIDE INFO--

--SHIPPED--

CRTS	QTY	LOCATN	UM	PART#	7 UPC	DESCRIPTION / SKN	ORD	LN	QTY	WT
1	36	W03911	EA	SL13-10-1		SS SPRNG 15" EXTC	10# BL	1	36	12